

Work Order ID 72605

Wednesday, August 03, 2011 1:04:52 PM

Page 1

Item ID: D4004-041

Revision ID:

Item Name: Side Restraint Angle



Start Date: 8/3/2011 Start Qty: 6.00

Required Date: 8/8/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: Date: 8-08-3 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4004	A								
100		0.00							
									
Waterjet									
FLOW CNC Waterjet									
2024 .063									
	Memo	0.00							
	1-Cut as per Dwg (D4004-1F)								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110		0.00							
									
QC									
Quality Control									
	Memo	0.00							

11-8-3

9

11-8-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

1- Bend D4004-1 as per Dwg
2- C'sink as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/3/04

8/3/04

8/3/04

29

29

29

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

9 0 11/08/05

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

1117338

Memo

0.00

Powder Coating

Start Time: 7:30 AM
Oven Temperature: 320° F
Finish Time: 8:00 AM

9 0 11/08/05

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 11/08/11 (9)

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Small Fab	Memo Assemble as per dwg	0.00							
Small Fab		0.00							
190 QC	QC5- Inspect part completeness to step on W/O Memo	0.00							
Quality Control		0.00							
200 Packaging	Identify as per dwg & Stock Location: <u>106-</u> Memo	0.00							
Packaging		0.00							

2/5/08/11 (9)

(8)

11/8/11 (90)

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/12
MF
11-08-11

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 03, 2011 1:04:58 PM

Page 1

Work Order ID: 72605

Parent Item: D4004-041

Parent Item Name: Side Restraint Angle





Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A 09.12.15 new issue Prelim EC verified by:DD IPP Rev:B
10.05.17 as per ECN10-562 DD verf:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063  2024-T3 .063 sheet		Purchased	No			100	sf	250.3800	0.22	1.389474			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT022				250.38					
				117018				25.88					
				117392				224.5					
D4004-3  Strut Lock Bracket		Manufactured	No			180	Each	9.0000	1				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				9					
				69804				9					
D4004-7  Hose Clip		Manufactured	No			180	Each	6.0000	1				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				6					
				69337				6					
MS20426AD4-4  Rivet		Purchased	No			180	Each	2,166.000	1				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST317				2166					
				116188				2166					

B11-8-3

(9)

117392

6
8/5/11/08/11

9

6
8/5/11/08/11

B 72662
(8)

6
8/5/11/08/11

9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, August 03, 2011 1:04:58 PM

Page 2

Work Order ID: 72605

Parent Item: D4004-041

Parent Item Name: Side Restraint Angle



Start Date: 8/3/2011

Required Date: 8/8/2011

Start Qty: 6.00

Required Qty: 6.00

MS20426AD4-5

Purchased

No

180

Each

5,493.000

2

12



Rivet



EP 11/08/11

Location

Loc Qty

Loc Code

MEZZ

289

6733

289

ST317

5204

6874

5204

18

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Shop Packet Print

Page 2

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DART AEROSPACE LTD		Work Order: 72605
Description: Side Restraint		Part Number: D4004-1
Inspection Dwg: D4004 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	2		V PB02	
Ø0.129	+0.005/-0.001	.130	2		V	
3.65	+/-0.030	3.650	2		V	
0.223	+/-0.010	.226	2		V	
10.63	+/-0.030	10.636	2		Prow 302	
2.99	+/-0.030	2.998	2		V	
5.79	+/-0.030	5.799	2		V	
0.87	+/-0.030	.868	2		V	
2.40	+/-0.030	2.400	2		V	
1.38	+/-0.030	1.378	2		V	
0.50	+/-0.030	.497	2		V	
0.79	+/-0.030	.788	2		V	
0.38	+/-0.030	.378	2		V	
0.98	+/-0.030	.983	2		V	
1.18	+/-0.030	1.177	2		V	
1.56	+/-0.030	1.562	X		V	
0.063	+/-0.010	.062	2		V	

Measured by: RB	Audited by: S	Preliminary Approval:	N/A
Date: 11-8-3	Date: 11/02/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.08.03	New Issue	KJ	MA

W/O:		WORK ORDER CHANGES					
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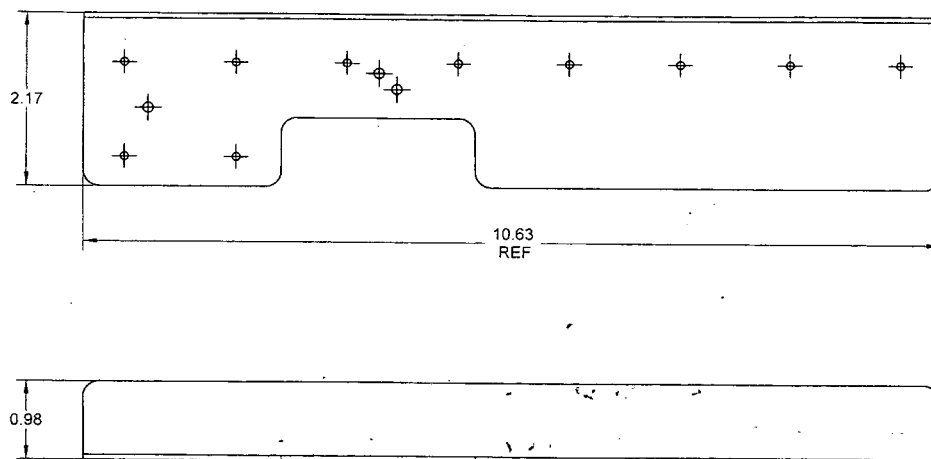
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-1	REF JCA-M47-2-19

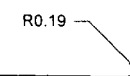


D4004-1 SIDE RESTRAINT

- NOTES:
- 1) MATERIAL: MADE FROM D4004-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.18 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO'
SUBJECT TO AMENDME
WITHOUT NOTICE
WORK ORDER
NO. 72605

RD11-08-3



RELEASED
2010-05-05
MD

DESIGN	<i>JS</i>	DART AEROSPACE LTD
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>JS</i>	DRAWING NO. D4004
MFG. APPR.	<i>JS</i>	REV. A
APPROVED	<i>JS</i>	SHEET 3 OF 11
DE APPR.	<i>JS</i>	TITLE SIDE RESTRAINT
DATE	10.02.10	SCALE NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

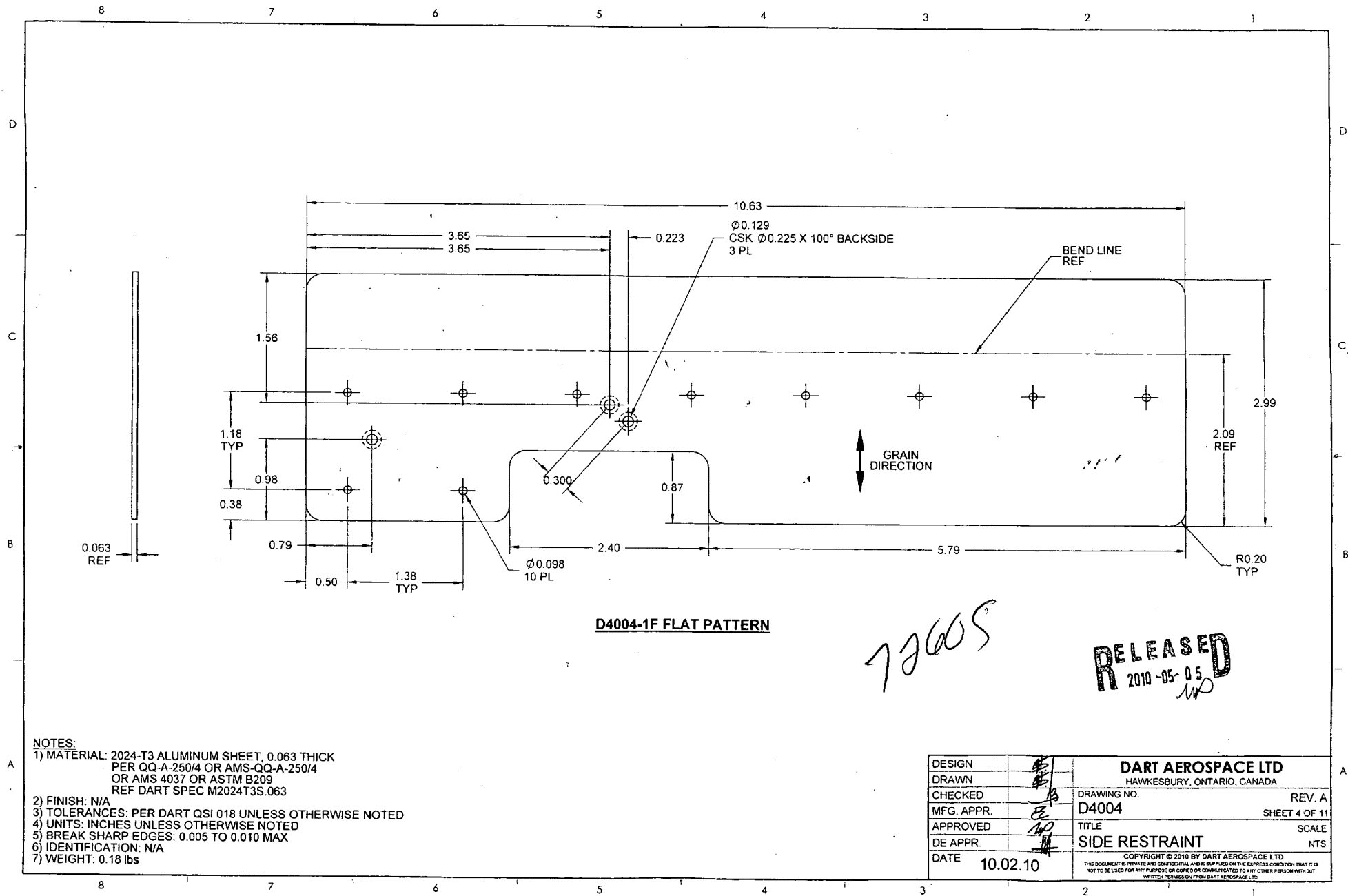
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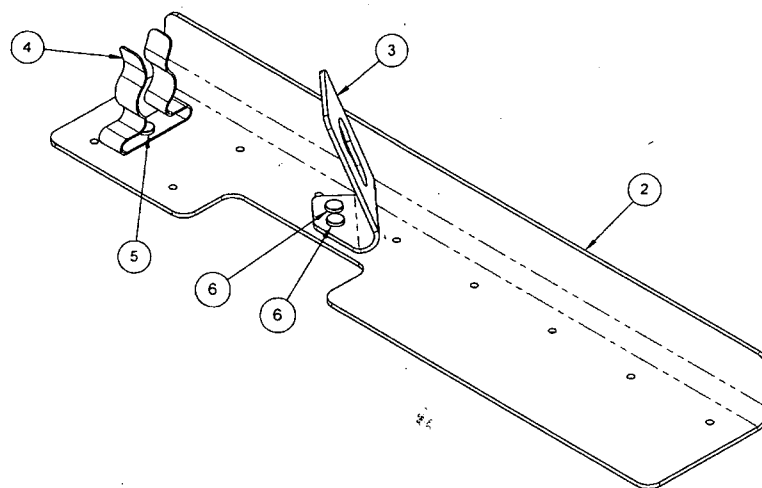
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-041	SIDE RESTRAINT ANGLE	JCA-M47-2-19
2	1	D4004-1	SIDE RESTRAINT	
3	1	D4004-3	STRUT LOCK BRACKET	
4	1	D4004-7	HOSE CLIP	
5	1	MS20426AD4-4	RIVET	
6	2	MS20426AD4-5	RIVET	



D4004-041 SIDE RESTRAINT ANGLE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.21 lbs

A	NEW ISSUE		10.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4004	REV. A
TITLE SIDE RESTRAINT	SCALE NTS
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RELEASED
2010-05-05
MP

72609

W/O:		WORK ORDER CHANGES					
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